

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009451**Date Inspected:** 03-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Xiao Zhong, You Qi Guo**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 11

This QA inspector randomly observed the following work in progress in Bay 11:

FCAW welding of weld joint ESTL4-2B/L-59B located inside PCMK east tower, lift 4, skin A to skin B between 119M and 123M diaphragms. Welder was identified as 049220. ZPMC QC was identified as CWI Liu Xiao Zhong (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-2231.

FCAW welding of weld joint ESTL4-2B/L-58B located inside PCMK east tower, lift 4, skin B to skin C between 123M and 127M diaphragms. Welder was identified as 040713. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2232.

FCAW welding of weld joint ESTL4-2B/L-61A located outside PCMK east tower, lift 4, skin D to skin E at approximately 130M elevation. Welder was identified as 070754. ZPMC QC was identified as CWI Liu Xiao Zhong (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-2231-TC-U4b-F.

FCAW welding of weld joints ED1-A149A/C-66, 67 located on PCMK east tower, skirt plate. Welder were identified respectively as 042218, 070140. ZPMC QC was identified as CWI You Qi Guo (QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-T-2132.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations except as noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
